Work Orde			AM			Page 1							
Item ID: Revision ID: Item Name:	D3572-041 Guide				Accept	*N90	nn41	<b>010</b>	<b>n*</b>	Setup	Start Stop		S1* S2*
Start Date:	11/3/2014	Start Qt	-	*4*		Cust Ite							
Required Date: Reference:	11///2014	Req'd Q	ty: 4.00	*4*		Custom	er:						 
Approvals:	Process Pla	an: <u> </u>	F	Date: 14-11-0			Date:		F	Run	Start	*NI	R1*
	QC:			Date:	SPC (Y/N):		Date:				Stop	*NI	R2*
Sequence ID/ Work Center II	D	Operatio Descripti			Set Up/ Run Hours	Tool I	D Tool	# Plan Code	Accept Qty	Rejo Qty		Reject Number	Insp. Stamp
Draw Nbr	Rev	ision Nbr			· · · · · · · · · · · · · · · · · · ·		•			-			
D3572	Rev	D											
100		Pick Kit	-	11000	0.00							·.	
*100* Packaging Packaging			Memo		0.00						-1-	NO	V 0 3 2014
110		Small Fab		·	0.00	·			,	¥-	F		
*110* Small Fab	•		Memo 1-Cut Tube 2-deburr be	e D3572-1 as per Dwg D3: oth ends	0.00 572	,			_4_			<u>NOV</u>	0 3 2014
120		QC5- Inspe	ct part comp	oleteness to step on W/O	0.00								DAS <b>38</b> 9-89
*120* QC Quality Control			Memo		0.00				(1)				NOV 0 3 2014

DQA:		Date:			<b>\^\^</b>									
QA Closed:		Date:			WORK ORDER NON	-C(	ONFO	RMANCE / L		ork Order up	odate only	AEROSPACE		
ar crosea.		Date.								ork Order up	date only			
Work Orde	er:				DISPOSITION				AGAINST D	EPARTMENT,	/PROCESS			
	<del></del>	-			Rework	1		Skid-tube	Crosstube	7	Water Jet	Engineering		
Part N	No.				Scrap			Machining	Small Fab	Pro	d. Eng. Coor.	Quality		
				_	Use-as-is			noforming	Finishing	<b>⊣</b>	re/Packaging	Other		
NCR N	No.				Suspected Unapproved			Large Fab	Composite	1	Supplier			
						•			• •	_				
Root				Desci	ription of work order update	١	Initial	A	ction	Sign &				
Cause	Date	Step	Qty		or non-conformance	Ch	ief Eng	Des	cription	Date	Verification	QC Inspector		
Design					·									
Doc/Data	Ц										•			
Equip/Tooling						·								
Handling/Pre										'				
Material														
Operator														
Offset/Setup														
Process <u>. 🧘 i</u>														
Supplier														
Training														
Transport														
Unapproved														
						FAI	ULT CAT	TEGORY						
Landi	ng Gear				General		•					_		
•	Bending				Bend		Folio/P	rogram		Outside Dim	ensions	Pressure/Forced		
		Not Conce	ntric	ļ	BOM/Route		Grain			Over/Under	tolerance	Set-up		
	Cracks				Broken/Damage/Defect		Hardwa	re		Part Incorred	ct	Temperature/Cure		
	Crimp/K	ink/Ripple	e/Wave		Burrs		Inspecti	ion Incomplete/l	Unqualified	Part Lost/Mi	ssing	Weld		
	Cuffs				Contamination		4	ions Incomplete	<u> </u>	Part Moved		Wrong Stock Pulled		
	· Crushing	3			Countersink		Misalig	ned/off center	·	Positioned V	Vrong	_		
	Heat Tre	eat			Cut Too Short		Mislabe	led		Power Loss/	Surge	Other		
	Inspecti	on Strip in	Tube		Drawing		Misread	t						
	Marks/0				Drill Holes	L	Off-set							
	Turning	Sequence			Finish		Out of 0	Calibration						
	Wave/Twist in Tube				Fit/Function		Out of S	Sequence						

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Work Orde Monday, Novem				*126	208*		1 1 1 1					Page 2
Item ID: Revision ID:	D3572-041			Accept	*N900	040	100	)*	Setup	Start Stop	17	S1*
Item Name: Start Date: Required Date: Reference:	Guide 11/3/2014 11/7/2014	Start Qty: 4.00 Req'd Qty: 4.00	*4* *4*		Cust Item I Customer:	D:				Stop	*N	S2*
Approvals:		an:		Tooling: SPC (Y/N):		ate:			Run	Start Stop	*N	R1* R2*
Sequence ID/ Work Center II	)	Operation Description Weld per dwg. A/R. Alu	minum rod Rotch: (14/)	Set Up/ Run Hours	Tool ID	Tool#	Plan Code	Accep Qty	t Rej Qty		Reject Number	Insp. Stamp
*130* Large Fab		Large Fab <b>Memo</b> 1-Weld D35	minum rod Batch: funda 672-3 guides and D3572-5 d flush at the end of tube of	0.00 bracket as per Dwg D3572					<u>/</u>	Œ	<u>/4-</u>	/2-/_
140 <b>*140</b> * QC		QC9- Inspect visual per	QSI004- Fusion Welds	0.00				<u>(4)</u>	14	اد- ٥	1	DAS 9 <u>9-89-</u>
Quality Control		QC5- Inspect part compl	leteness to step on W/O	0.00								das 9
*150* QC		Memo		0.00				4		1-12-	01	9-89

Memo

Quality Control

DQA:			Date:													
						<b>WORK ORDER NON</b>	-CC	ONFO	RMANCE / L	JPDATE			AEROSPACE			
QA Closed:			Date:							V	Vork Order up	date only				
Work Ord	er:					DISPOSITION				AGAINST D	EPARTMENT,	PROCESS				
Part I	۔ No.					Rework Scrap	]		Skid-tube . Machining	Crosstube Small Fab	Pro	Water Jet d. Eng. Coor.	Engineering Quality			
NCR 1	-					Use-as-is Suspected Unapproved		· -		Finishing Composite	Rec/Store/Packaging Supplier		Other			
Root				·	Desci	ription of work order update		nitial	A	ction	Sign &					
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Des	cription	Date	Verification	QC Inspector			
Design Doc/Data Equip/Tooling Handling/Pre Material Operator Offset/Setup Process Supplier Training Transport Unapproved			*		£											
			•				FAI	ULT CAT	TEGORY				······································			
Landi	ng G	iear				General										
		Bending Centre No Cracks	ot Concer	ntric		Bend BOM/Route Broken/Damage/Defect		Folio/P Grain Hardwa	Program ire	_	Outside Dim Over/Under Part Incorred	tolerance	Pressure/Forced Set-up Temperature/Cure			
		Crimp/Kin	ık/Ripple	/Wave		Burrs		Inspecti	ion Incomplete/U	Jnqualified	Part Lost/Mi	ssing	Weld			
	_,	Cuffs				Contamination		Instruct	ions Incomplete,	/Unclear	Part Moved		Wrong Stock Pulled			
		Crushing				Countersink		Misalig	ned/off center		Positioned V	/rong	· .			
		Heat Trea	t			Cut Too Short		Mislabe	eled		Power Loss/	Surge	Other			
	Inspection Strip in Tube				Drawing		Misread	b			·					
		Marks/Ch	atter			Drill Holes		Off-set								
		Turning Se	equence			Finish		Out of 0	Calibration							
	Wave/Twist in Tube					Fit/Function Out of Sequence										

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Work Orde				*126					Page 3			
Revision ID:	D3572-041 Guide			Accept	*N900	ი4ი	100	)*	Setup	Start Stop	*N:	S1* S2*
Start Date: Required Date: Reference:	11/3/2014 11/7/2014	Start Qty: 4.00 Req'd Qty: 4.00	*4* *4*		Cust Item I Customer:	D:				<b>G</b> : 1		
Approvals:		n:	Date:	Tooling: SPC (Y/N):		ate:			Run	Start Stop	*N	R1* R <i>2</i> *
Sequence ID/ Work Center II	)	Operation Description Chemical Conversion Coa	at per QSI005 4.1	Set Up/ Run Hours	Tool ID	Tool#	Plan Code	Accept Qty	t Rej Qty	<b>y</b> .	Reject Number	Insp. Stamp
*120* HandFinish Hand Finishing		Memo		0.00			====		_ Ø 	/7-	12-2	
190 *100* Powdercoat Powder Coating		Grey Sandtex(Ref:4.3.5.6)  Memo  START TIM  OVEN TEM  FINISH TIM	E: <u>3:20</u> PERATURE: <i>32</i> 0	0.00 0.00				4-	Ø_	p4-,	12-3	. <u>0</u> 8

0.00

0.00

QC3- Inspect Part Finish

Memo

200

\*200\*

Quality Control

DAS 38 9-89

DEC 0 4 2014

DQA:		Date:												
					WORK ORDER NON-	-CC	ONFO	RMANCE / UPDATE				AEROSPACE		
QA Closed:	<del> </del>	Date:							W	ork Order up	date only			
Work Orde	er:				DISPOSITION			AGAINS	T DE	EPARTMENT,	/PROCESS			
					Rework			Skid-tube Crosstub	e 🗀	7	Water Jet	Engineering		
Part N	lo.				Scrap			Machining Small Fa	- ⊢	Pro	d. Eng. Coor.	Quality		
					Use-as-is		Therr	noforming Finishir	ıg	Rec/Sto	e/Packaging	Other		
NCR N	lo		<u></u> .	<del></del>	Suspected Unapproved			Large Fab Composit	:e	]	Supplier			
Root				Desci	ription of work order update	ı	nitial	Action	-	Sign &				
Cause	Date	Step	Qty		or non-conformance	Ch	ief Eng	Description		Date	Verification	QC Inspector		
Design					•									
Doc/Data										1				
Equip/Tooling	_													
Handling/Pre														
Material'														
Operator														
Offset/Setup	_													
Process														
Supplier					•									
Training Transport														
Unapproved											,			
опарріочен	<b>_</b>		<u> </u>	l		FAI	ULT CA	TEGORY		<u></u>				
Landir	ng Gear				General						· <del> ·</del> · · · · · · · · · · · · · · · · ·			
. •	Bendin	g			Bend		Folio/F	Program	Г	Outside Dim	ensions	Pressure/Forced		
	<b>─</b>	Not Conce	ntric		BOM/Route		Grain			Over/Under	<b>⊢</b>	Set-up		
ļ	Cracks				Broken/Damage/Defect		Hardwa	are		Part Incorre	ct –	Temperature/Cure		
Ì	Crimp/	Kink/Ripple	e/Wave		Burrs		Inspect	ion Incomplete/Unqualified		Part Lost/Mi	ssing	Weld		
	Cuffs				Contamination		Instruct	tions Incomplete/Unclear		Part Moved		Wrong Stock Pulled		
	Crushii	ng			Countersink		Misalig	gned/off center		Positioned V	Vrong			
	Heat T	reat			Cut Too Short		Mislabe	eled		Power Loss/	Surge	Other		
[	Inspec	ion Strip ir	Tube		Drawing		Misread	d						
[	Marks	Chatter .			Drill Holes		Off-set							
	Turnin	g Sequence	!		Finish		Out of	Calibration						
	Wave/Twist in Tube				Fit/Function	Out of Sequence								

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Work Ord Monday, Novem				*126					Page 4			
Item ID: Revision ID: Item Name:	D3572-041 Guide			Accept	*N900	<b>040</b>	100	<b>)</b> *	Setup	Start Stop	1 71	S1* S2*
Start Date: Required Date: Reference:	11/3/2014	Start Qty: 4.00 Req'd Qty: 4.00	*4* *4*		Cust Item I Customer:							
Approvals:	Process Pla	an:	Date:	Tooling: SPC (Y/N):	Da		Run	Start Stop	^IVI	R1* R2*		
Sequence ID/ Work Center I 210 *210* Packaging Packaging	D	Operation Description Identify as per dwg & Sto	ck Location:	Set Up/ Run Hours 0.00	Tool ID	Tool#	Plan Code	Accep Qty	t Re Qt	ject y	Reject Number	Insp. Stamp

220

QC21- Final Inspection - Work Order Release

0.00

\*220\*

Memo

0.00

Quality Control

DQA:			Date:										DAD'T
						WORK ORDER NON-	-CC	ONFO	RMANCE / U	PDATE			AEROSPACE
QA Closed:			Date:					. <u>-</u>			Nork Order up	odate only	
Work Orde	er:					DISPOSITION				AGAINST [	DEPARTMENT,	/PROCESS	
	-					Rework			Skid-tube	Crosstube		Water Jet	Engineering
Part N	No.					Scrap			Machining	Small Fab	Pro	d. Eng. Coor.	Quality
	-		-		_	Use-as-is		Thern	noforming	Finishing	Rec/Sto	re/Packaging	Other
NCR I	۷o. <mark>-</mark>	·	· · · · · ·			Suspected Unapproved			Large Fab	Composite		Supplier	
Root					Desci	ription of work order update	Ī	nitial	Ac	tion	Sign &		
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Desc	ription	Date	Verification	QC Inspector
Design	Ш												
Doc/Data	Ц												
Equip/Tooling				,									
Handling/Pre	Ш	, de-											
Material -	Ш	* - **	. 1										
Operator	Ш												
Offset/Setup	Ш						ļ						
Process	Ш												
Supplier	Щ		<u> </u>										
Training	Ш		!										
Transport	Щ												
Unapproved									<u> </u>				
							FAL	ULT CAT	regory		ε,		
Landi						General		1		Г			<b>-</b>
	-	Bending			<u> </u>	Bend		1	rogram	-	Outside Dim	<b> </b>	Pressure/Forced
	Н	Centre No	t Concer	ntric	<u> </u>	BOM/Route		Grain		-	Over/Under	<b>⊢</b>	Set-up
		Cracks	. /n: :	6.4.1	<u> </u>	Broken/Damage/Defect	<u> </u>	Hardwa			Part Incorre	<u> </u>	Temperature/Cure
,	-	Crimp/Kin	k/Ripple	/Wave	<del>-</del>	Burrs	<u> </u>	1 '	on Incomplete/U	· -	Part Lost/Mi	- J	Weld
	$\vdash$	Cuffs			-	Contamination	$\vdash$	1	ions Incomplete/	Unclear	Part Moved		Wrong Stock Pulled
<i>*</i>	⊢⊣	Crushing			-	Countersink	$\vdash$	1 -	ned/off center		Positioned V		<b>7</b>
	Н	Heat Trea			<u> </u>	Cut Too Short	-	Mislabe		L	Power Loss/	Surge	Other
	Inspection Strip in Tube		-	Drawing	$\vdash$	Misread	i						
	Marks/Chatter				-	Drill Holes		Off-set					ı
	$\vdash$	Turning Se	•		<u> </u>	Finish	<u> </u>	4	Calibration				
	Wave/Twist in Tube			e		Fit/Function	/Function Out of Sequence						

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Page 1

Work Order ID: 126208

\*126208\*

**Parent Item:** 

D3572-041

\*D3572-041\*

Parent Item Name: Guide

**Start Date:** 11/3/2014

Required Date: 11/7/2014

Start Qty: 4.00

Required Qty: 4.00

**Comments:** 

IPP Rev:A New Issue 07-02-07 JLM

IPP rev B revB dwg EC

IPP Rev:C Removed D3572-7 Cap 07-06-11 JLM

IPP Reven 08-05-27 Peview process of IPP DD verified by EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3572-3		Manufactured	No			130	Each	27.0000	4	16			
*D3572-3*									**	EZ	14-1	1-28	
				Location		Loc	<u>Oty</u>	Loc Code					
				WA002			27						
					119368		$-\frac{3}{24}$			<del></del>			
D3572-5		Manufactured	No		122903	130	24 Each	13.0000	1	<del></del>			
*D3572-5*									**	Ø	14-11	-28	
				Location	Į.	Loc	<u>Oty</u>	Loc Code					
\$ .				WA002			13		_				
				· · · · · · · · · · · · · · · · · · ·	122941		13						
M6061T6T1.000W.188		Purchased	No			110	f	178.7463	2.34	10		MOV	0 3 201
*M6061T6* 6061T6 RD TUBE 1.00 X .18		W 188*							**		FF	NUV	U 3 ZVI
				Location	,	Loc	Otv	Loc Code					

Location	Loc Oty	Loc Code	
MAT016	74.6443		
m128248	74.6443		<del></del>
MAT030	104.102		
117797	6.75		
120935	0.461		
121848	16.5		10
122114	3.121		
m126686	77.27		

DQA:			Date:	Date:											
QA Closed:			Date:			WORK ORDER NON	-CC	NFOI	RMANCE / UI		Wo	ork Order up	date only		AEROSPACE
Work Orde	er:					DISPOSITION		,		AGAINST	DE	PARTMENT	PROCESS		
Part N	 lo					Rework Scrap Use-as-is Suspected Unapproved		Thern	Skid-tube  Machining  noforming  Large Fab	Crosstube Small Fab Finishing Composite	-		Water Jet d. Eng. Coor. e/Packaging Supplier		Engineering Quality Other
Root					Desc	ription of work order update	li	nitial	Act	ion		Sign &			
Cause		Date	Step	Qty		or non-conformance	Chi	ief Eng	Descr	ription		Date	Verificatio	n	QC Inspector
Design Doc/Data Equip/Tooling   Handling/Pre Material Operator Offset/Setup Process Eupplier Training Transport Unapproved															
							FAL	JLT CAT	TEGORY	4					
Landi					·	General						, 1 .			
166. T				e/Wave		Bend BOM/Route Broken/Damage/Defect Burrs Contamination Countersink Cut Too Short Drawing	Folio/Program Grain Hardware Inspection Incomplete/Unqualified Instructions Incomplete/Unclear Misaligned/off center Mislabeled Misread				Outside Dime Over/Under Part Incorred Part Lost/Mi Part Moved Positioned W Power Loss/S	tolerance et ssing /rong		Pressure/Forced Set-up Temperature/Cure ( Weld Wrong Stock Pulled Other	
-	<del></del>					Drill Holes	-	Off-set	Calibration						· · · · · · · · · · · · · · · · · · ·
	Turning Sequence Finish  Wave/Twist in Tube Fit/Function					Out of Calibration Out of Sequence									